Digital Serigraphic Technologies
BY BJØRN THORSEN A/S

Technical Data Sheet

DST HPI Foil, 120µ (codes 107700, 107740, 107760)

Product description

DST HPI Foil, 120µ is a *full matt* digital printable PET release liner, thermostabilized, with release and anti-static coating, suitable for HP Indigo and DST-compatible toner printers.

DST HPI Foil, 120µ provides a cold peel release and enables vibrant matt transfer colors.

Physical properties	Value[1] (SI)	
Available sheet size	a) 320x460mm/12.6x18.1" - b) 330x480mm/13.0x18.9" - c) 500x700mm/19.7x27.6"	
DST code	a) 107700, b) 107740, c) 107760	
Base material	PET	
Thickness	120µm	
Coating	Double matt, release and anti-static coating	
Peel type	Cold peel/20-45s	
Dimensions	± 0.5mm	
Stability	Low shrinkage	ASTM D1204 MD: ≤0.3% TD: ≤0.3%
Transfer aspect	Full matt	
Printer compatibility	HP Indigo and DST-compatible toner printers like Ricoh, OKI Pro 9541WT and other	

[1] Values listed here are typical averages and should not be taken as our Product Specification. DST reserves all rights.

Recommended use guidance

For HPI Series 2 & Series 3 printers, please refer to section below.
For DST-compatible toner printers, consult recommendations from machine manufacturer with related media size, thickness and type.

Additional information

According to EU REACH, the coated paper liner is an article. EU REACH Substances listed Very High Concern (SVHC) are no intentional components of this product. Therefore, it is likely those substances are contained in the product in quantities of less than 0.1%.
Storage considerations: When stored at room temperature in its original sealed packaging, in a dry place, the product can be expected to remain stable for 3 years under normal conditions.

Contact information

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Guidance for heat transfer print of DST A/S release liners using HP Indigo Series 2 & 3 Digital press

1. Prepress
   - You create images/designs/artwork on computer, considering the image prints mirrored, so images/ designs/ artwork, to be transferred onto the garment, print properly.
   - You may add eye marks or code for post-printing & finishing steps.
2. Preparation of release liners
   - Release liners (a.k.a. transfer material) are based on special release coating with a DST A/S proprietary surface coating, optimized for HP Indigo printing.
   - You print images on release liners on HP Indigo - Series 2 (or 5000 Series) or - Series 3 (or 7000 Series) presses.
   - You put as many images on one liner sheet as possible to minimize liner waste.
   - You end up with x number of identical release liners (sheets) with images that you put aside for now.
   - To reduce liners transport issues, wait several hours, preferably 24h, before printing, acclimate substrates
     to printing conditions in a humidity-controlled environment. Optimal conditions are ambient temperature, i.e. 20-25°C and relative humidity of 50-70%. Store the release liner in its original wrapper.
3. Printing
   - The printing method is multi-shot mode.
   - Define substrate name or select appropriate dimensions (width 320mm, length 460mm), weight and thickness, as well as gloss level (semi-matt or full matt), white face stock and no back paper.
   - Better prints are obtained when calibration is made with the thick impression paper. Adjust depending on weight and thickness of DST HPI Paper or DST HPI Foil.
   - Digital Serigraphic Technology A/S is constantly improving the quality and the compatibility of the DST HPI Paper and DST HPI Foil to work with HP Indigo Series 2 & Series 3 presses.

     The following values presented below should only be a *recommended starting setting point*. Before starting production with a new material or a new batch, a quick validation of settings is recommended to find best working parameters. Further indications are given in the troubleshooting section on the following page.

     Press parameters for HP Indigo 5900 (Series 2)
     - Blanket temperature setting of 140°C to 150°C
     - Automatic blanket force

     Press parameters for HP Indigo 7900 and 7K (Series 3)
     - Blanket temperature setting of 100°C
     - Automatic blanket force (best range is 220-240kg)
4. Post-printing
   - The post-printing process of the heat transfer application on garment is described in **DST Product Technology Guidance Document***, available upon request.*

Troubleshooting section: printing issues

If you encounter different printing issues, for instance partial image print or low ink adhesion, you can use the following tips:

- Increase blanket temperature by increments of 10°C, as the surface will heat more to make the image dryer
  when passing on the blanket. The image should be transferred fully.
  - Note that HP Indigo Series 3 press has more temperature settings.
- Increase the second transfer force, by increment of 20kg.
  - Note that HP Indigo Series 3 press has a higher force.
- Decrease blanket temperature by 5 to 10°C to get a tackier film and improve ink adhesion on the release liner.
- Real blanket temperature can be measured by IR thermometer, ideal maximum temperature of 90°C during run.